

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

March 21, 2016 3:33:00 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

115

0.00

1 15

Dry Material

0.00

HandThermo

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245 deg. F

MAR 23 2016

Time IN: 5:00 PM

Per

TIME IN: 6:00 AM

Time OUT:

120

0.00

120

THERMOFORMING MACHINE

0.04

Thermoform

Memo

Thermoforming Machine

Thermoform as per Dwg. D3774-1and Folio

Dwg. Rev. **B**

Folio Rev. C

Visually inspect for proper formation of each part

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OTHER : ☐					

Work Order ID 143701

March 21, 2016 3:33:00 PM

143701

Page 3

Item ID: D3774-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Bottom, LH/RH
Start Date: 3/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/8/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.04				4			DAS 07 9-89 14/03/24
150 *150* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				6			DAS 07 9-89 14/03/24
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				⑤ 1603-30			DAS 07 9-89 9 9-89

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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
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Work Order ID 143701

March 21, 2016 3:33:00 PM

143701

Page 4

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Revision ID: Stop ***NS2***
Item Name: Seat Bottom, LH/RH
Start Date: 3/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/8/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>St250</u>	0.00				<u>6</u>			<u>600</u>
170									
Packaging	Memo	0.00							
Packaging								MAR 24 2016	
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01				<u>MCS</u>			MAR 24 2016
Quality Control									

MCS MAR 24 2016

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

March 21, 2016 3:33:04 PM

Page 1

Work Order ID: 143701

143701

Parent Item: D3774-1

D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV.B Dwg. Update 08.08.19 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased		No		110	sf	2,813.093	10.667	75.29647			DAS 07 9-89

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

16/03/23.

Location

Loc Qty

Loc Code

MAT018

2813.093

m133111

404.093

m134389

2409

50.7 sq ft
25.1 sq ft.

DART AEROSPACE LTD		Work Order:	
Description: Seat Bottom		Part Number:	D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

DAS

Measured by: **07**
9-89

Date: 16/03/23

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.32"	✓			
33.9	+/-0.100	33.8"	✓			
17.4	+/-0.100	17.5"	✓			
0.085	Min	0.087"	✓			
0.100	Min	0.115"	✓			
0.100	Min	0.120"	✓			
0.100	Min	0.116"	✓			
0.100	Min	0.113"	✓			

DAS

Measured by: **07**
9-89

Date: 16/03/24

Audited by: DAS
9

Date: 16-03-30

Prototype Approval: 9-89

Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	

DQA: _____ Date: _____

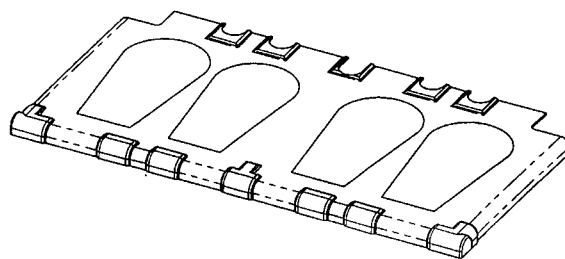


WORK ORDER NON-CONFORMANCE / UPDATE

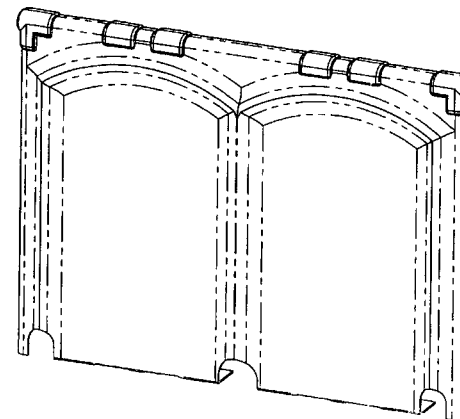
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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
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		OTHER :							



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED
08-08-11/11

20160321

SA 143701

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3774	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SEAT	NTS	
DATE	08.07.25		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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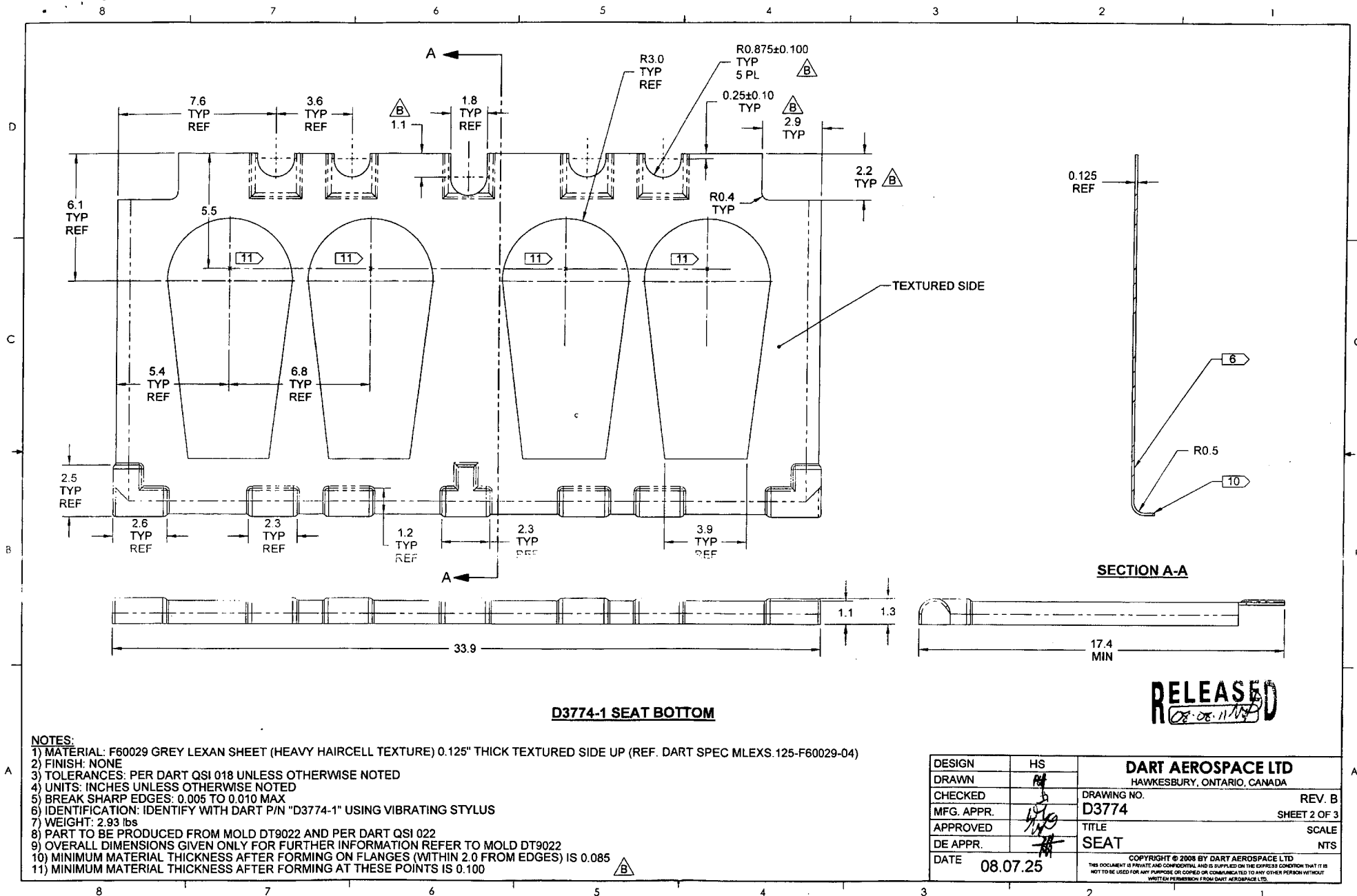


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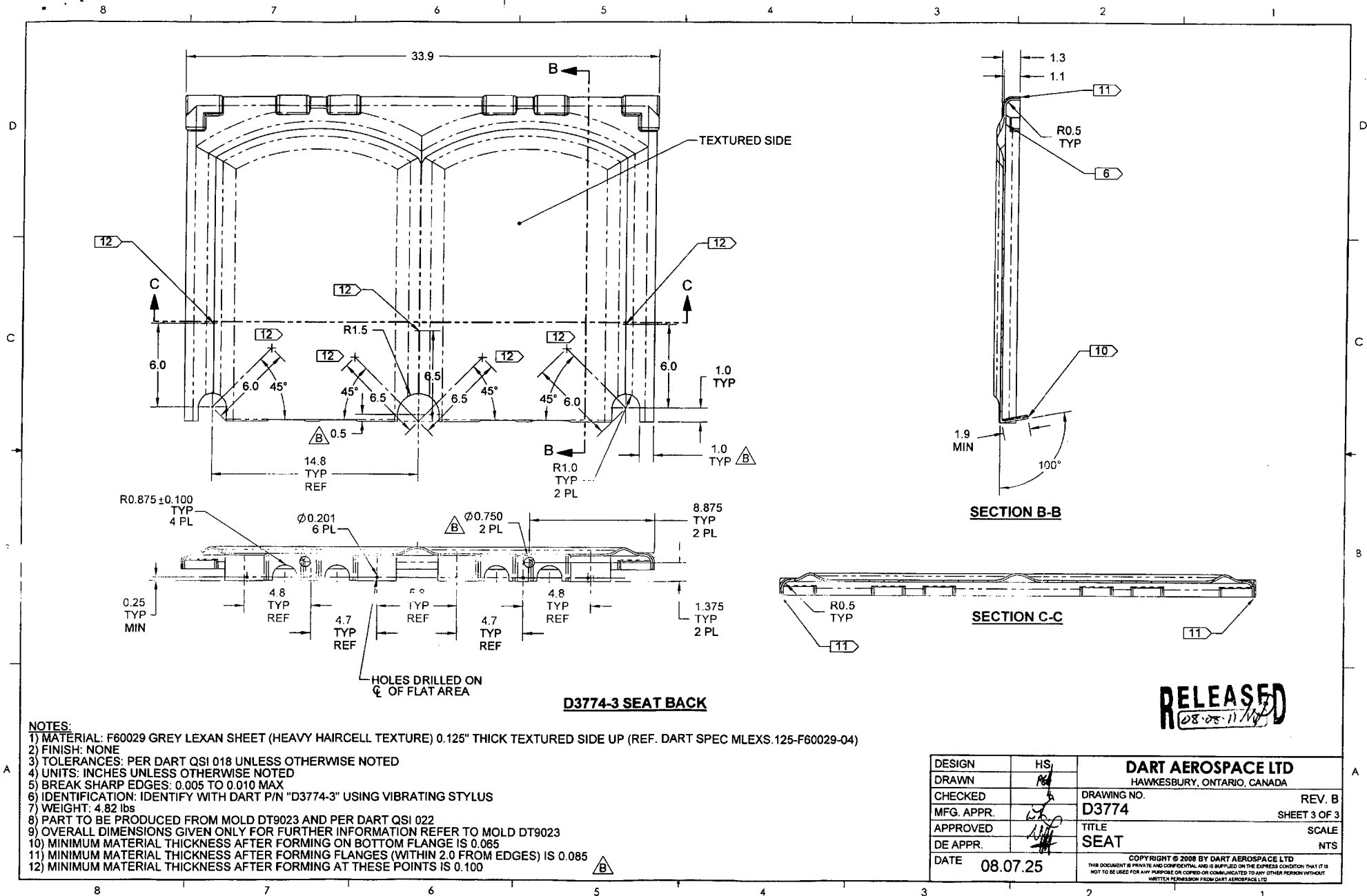


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DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3774	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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OTHER : ☐					